

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010928**Date Inspected:** 29-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M.Manikandan was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (6AW)

SMAW Process:

Welding of weld joint – 005 located on PCMK CA025, Corner assembly longitudinal weld. Welder is identified as 062092. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-Tc-U4b-FCM-1.

OBG # TRIAL ASSEMBLY YARD (6BW)

SMAW Process:

Welding of weld joint – 001 located on PCMK CA027, Corner assembly longitudinal weld. Welder is identified as 220069. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-Tc-U4b-FCM-1.

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OBG # TRIAL ASSEMBLY YARD (5BW)

SMAW Process:

Welding of weld joint – 005 located on PCMK OBW5G, Counter weight connection plate. Welder is identified as 048659. ZPMC CWI is identified as Li Yang. Welding was been performed against welding repair report # B-WR8588 Rev. 0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1.Y locations are identified as 780 and 3840mm.

OBG # TRIAL ASSEMBLY YARD (5BW)

SMAW Process:

Welding of weld joint – 006 located on PCMK OBW5G, Counter weight connection plate. Welder is identified as 048659. ZPMC CWI is identified as Li Yang. Welding was been performed against welding repair report # B-WR8589 Rev. 0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.Y locations are identified as 470 and 990mm.

OBG # TRIAL ASSEMBLY YARD (6AW-6BW)

SMAW Process:

Welding of Complete Joint Penetration weld joint located on longitudinal diaphragm to bottom panel of 6AW (PP40-PP41) crossbeam side. Welder is identified as 048659. ZPMC CWI is identified as Li Yang. Welding was been performed against welding repair report # B-WR8922 Rev. 0. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F)-FCM-Repair.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan	Quality Assurance Inspector
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Reviewed By:	Miller,Mark	QA Reviewer
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